

Rush

Work Order ID 135786

August 20, 2015 9:33:33 AM

135786

Page 1

Item ID: 647.7714

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Strut Tube

Start Date: 8/20/2015

Start Qty: 6.00 *6*

Cust Item ID:

Required Date: 9/3/2015

Req'd Qty: 6.00 *6*

Customer:

Reference:

Approvals:

Process Plan: SA

Date: 20150820

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

647.7700

A

110

0.00

110

Mill Conv

Memo

0.01

Conventional Milling Machine

1- CUT AS PER DWG
2- Mill end of tube as per dwg
3- DEBURR AS PER DWG

10 0 JCL 8/20/15

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

10 0 JCL 8/20/15

125

QC8- Inspect parts - second check

0.00

125

QC

Memo

0.00

Quality Control

10 0 JCL 8/20/15

DAS
38
9-89
AUG 20 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																									
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

August 20, 2015 9:33:39 AM

Page 1

Work Order ID: 135786

135786

Parent Item: 647.7714

647 7714

Parent Item Name: Strut Tube

Start Date: 8/20/2015

Required Date: 9/3/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 15.01.07 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.500W.083		Purchased	No				f	24.6980		3.789474			

M4130NT0 500W 083

4130 RD tube .500 x .083W

Location

Loc Qty

Loc Code

MAT032

24.698

124293

0.698

M132941

24

0.698 J.C.L. 15/08/20
2.7813 + 2.234

APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

04741

SHEET 1 OF 1

DWG NO. 647.7700

REV: NC

PREPARED BY J. SOTO

DATE: 11/13/2014

EFFECT ON DWG
☒ INC. ☐ UNINC.

DWG TITLE: STRUT ASSY

APPROVED BY:

ENGR

[Signature]

MFG

[Signature]

QC

[Signature]

EFF.

NEXT ORDER

TRANSACTION CODES (TC):

A-ADD
R-REVISE

C-CREATE
D-DELETE

REASON: CREATED NEW CONFIGURATION. ADDED F/N 5.

SH 20150820
135786.

5	A	647.7714	1	STRUT TUBE	△	
4	R	647.7713	1	STRUT THREAD	△	
3	R	647.7712	1	STRUT TUBE	△	△
	C	647.7703	X	STRUT ASSY		
F/N	TC	PART NUMBER	.7703			
		QTY		DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:				CHANGE CATEGORY		
				DER REVIEW REQUIRED		

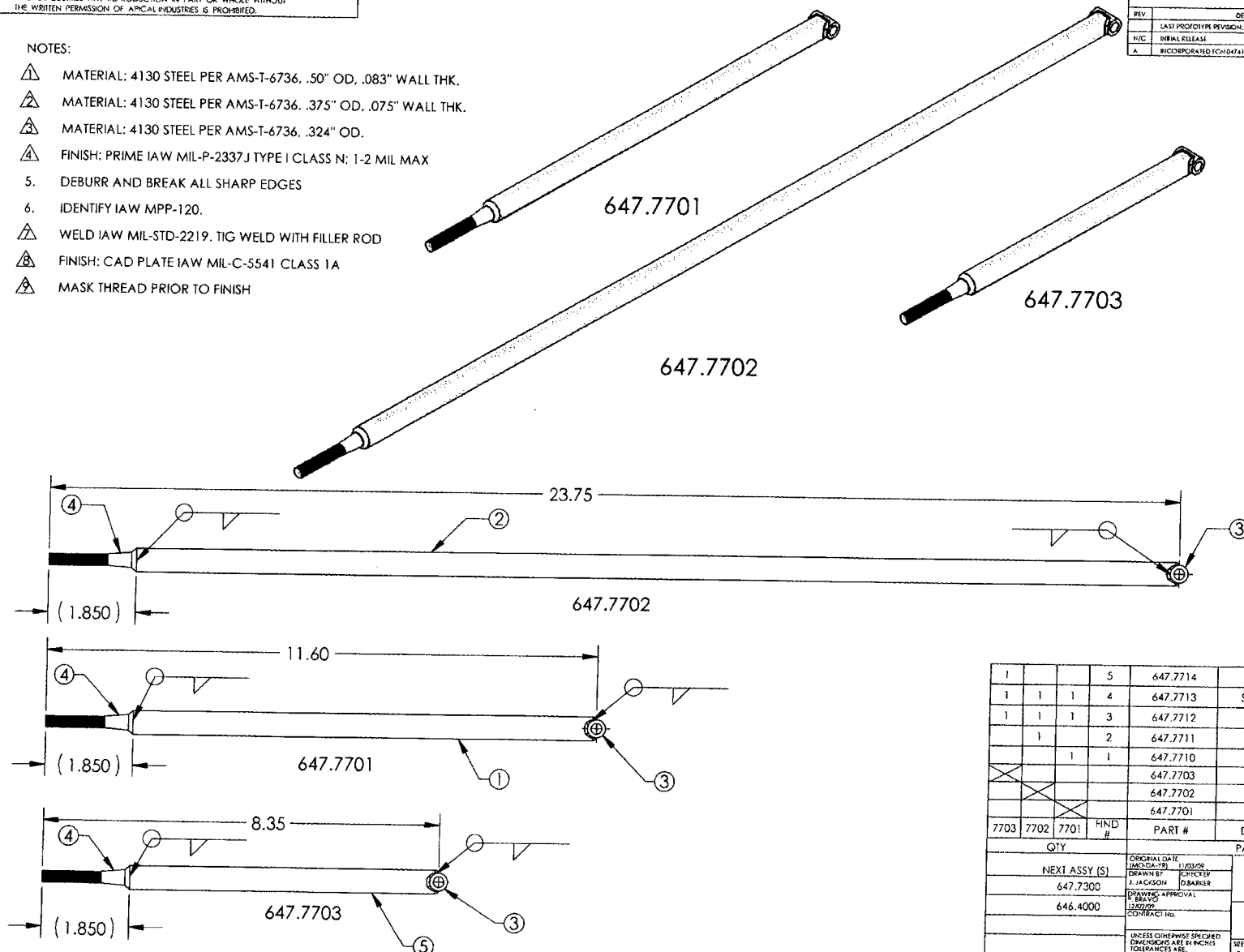
☐ MDL
 ☐ INSTALL INSTRUCTIONS
 ☐ ICA
 ☐ FMS
 ☒ BOM

☐ MAJOR
 ☒ MINOR

☐ YES
 ☒ NO

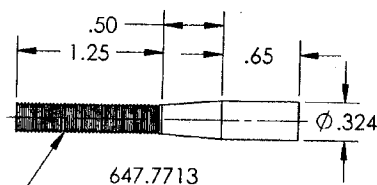
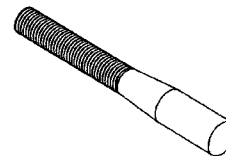
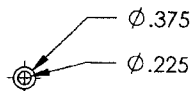
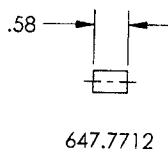
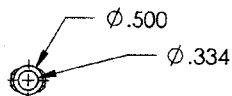
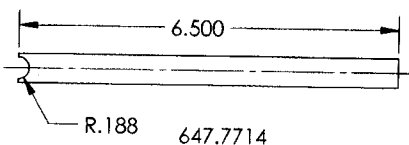
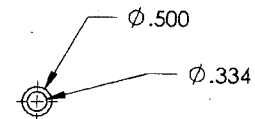
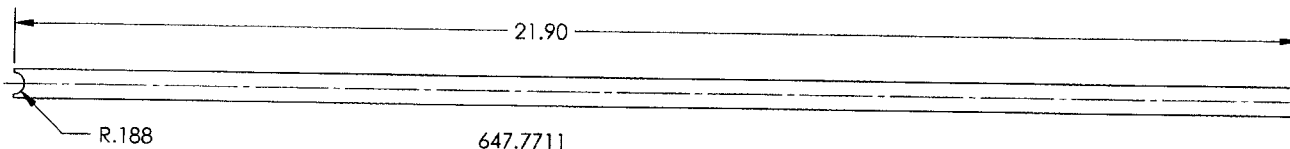
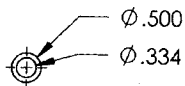
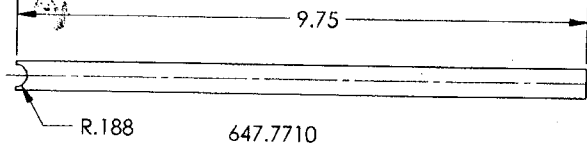
1. MATERIAL: 4130 STEEL PER AMS-T-6736, .50" OD, .083" WALL THK.
2. MATERIAL: 4130 STEEL PER AMS-T-6736, .375" OD, .075" WALL THK.
3. MATERIAL: 4130 STEEL PER AMS-T-6736, .324" OD.
4. FINISH: PRIME IAW MIL-P-2337J TYPE I CLASS N; 1-2 MIL MAX
5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MPP-120.
7. WELD IAW MIL-STD-2219. TIG WELD WITH FILLER ROD
8. FINISH: CAD PLATE IAW MIL-C-5541 CLASS 1A
9. MASK THREAD PRIOR TO FINISH

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISION, PR2		NIC
N/C	INITIAL RELEASE	12/03/09	P. BRAVO
A	INCORPORATED FCN 04761	11/13/14	P. BRAVO



1			5	647.7714	STRUT TUBE	△	
1	1	1	4	647.7713	STRUT THREAD	△	△
1	1	1	3	647.7712	STRUT TUBE	△	
	1		2	647.7711	STRUT TUBE	△	
		1	1	647.7710	STRUT TUBE	△	
				647.7703	STRUT ASSY		△ △
				647.7702	STRUT ASSY		△ △
				647.7701	STRUT ASSY		△ △
7703	7702	7701	HIND #	PART #	DESCRIPTION	MAT'L	SPEC.
QTY				PARTS LIST			
NEXT ASSY (S)				APPLIED INDUSTRIES			
647.7300				2608 TEMPLE HEIGHTS DR.			
646.4000				OCEANSIDE, CA. 92056-3512 (760)724-5300			
				STRUT ASSY			
ORIGINAL DATE: JAN 1992 DRAWN BY: J. JACKSON CHECKED BY: D. BARKER APPROVED BY: [Signature] APPROVAL DATE: 1/28/92 CONTRACT NO.				RE: CAGL CODE B. 07426 PART NAME	DWG. NO. 647.7700 L	REV. A	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± .1°				SHEET 1 OF 2			

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ORIGINAL DATE 11/03/00		APICAL INDUSTRIES	
DRAWN BY J. JACKSON		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CHECKED BY D. MARKER		STRUT ASSY	
DRAWING APPROVAL P. BRAVO		DWG. NO. 647.7700	
CONTRACT NO.		REV. A	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES (TOLERANCES ARE): 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SIZE B	SCALE: NONE
		QTY. NO. 07M26	SHEET 2 OF 2

